


1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO 2014-34
6. Item	7. Description Cargo Basket	8. Part Number 94610-01	9. Qty. 1	10. Serial/Batch No. 94601-11	11. Status/Work New
12. Remarks Modified with Lid Walkway IAW DCL704					
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12		
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature	
13d. Name Jeff Clarke - AD02		13e. Date (dd/mm/yyyy) 26 Mar 2015		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mm/yyyy)	
<p align="center">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>					

7228

CARGO BASKET BODY FABRICATION - COMMON

General

These instructions apply to all cargo basket body assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

Bell 206L/407 – Right side only

69811, Revision 3 – Standard Low Mounted Basket

94511, Revision 0 – Extra-Wide Low Mounted Basket

→ 94611, Revision 0 – Extra-Wide Low Mounted Ski Basket

76611, Revision 0 – High Mounted Ski Basket

Options 70404, Revision 2 – Front end cutout – 698

70411, Revision 0 – Front end cutout – 945/946

Eurocopter AS350/AS355 – left or right

77611, Revision 1 – Short Basket

76411, Revision 3 – Medium Basket (left or right)

78411, Revision 2 – Long Basket

94011, Revision 0 – Extra Large (ski) Basket

Options 70406, Revision 2 – Front end cutout – 764/776/784/940

Robinson R44 – left or right

90611, Revision 0 – Standard Basket (left or right)

Bell 206B – right side only

80211, Revision 0 – Short Basket

80311, Revision 0 – Medium Basket

81111, Revision 0 – Long Basket

Options 70406, Revision 2 – Front end cutout – 802/803/811

Bell 429 – right or left

95911, Revision 0 – Standard Basket

Bell Medium – left or right

75111, Revision 0 – Standard Basket

95511, Revision 0 – Extra Large (ski) Basket

Options 70407, Revision 1 – Front end cutout – 751

704, Revision – Front end cutout – 955

MD600

82811, Revision 0 – Standard Basket

Options – Applicable to all models

70403, Revision 5 – Auxiliary Latch

2014-34

Bell 206L/407 XL ski x1

CARGO BASKET BODY FABRICATION - COMMON

Complete
(initial or SCA #)

1 Work Order: 2014-34

Date Open: 25 MAR 2014

1. Rim Assembly – Basket Body

- a. Cut and fit $\frac{3}{4}$ " x 0.035 material to fit rim jig.
 - i. 1 or 2 lid prop bushing holes in short tube – refer to drawing
- b. Record material PO on attached material list.
- c. Remove writing on tubes with acetone and scotch bright.
- d. For extra large baskets – drill #30 (0.129) vent holes to vent stringer tubes into rims.
- e. 94611 (206L/407 XL ski) only – drill for 4 threaded bushings before assembling rim.

AD02

2. Weld Rim Assembly.

- a. Record welding rod PO on attached material list.
- b. 94611 (206L/407 XL ski) only – weld 4 threaded bushings into inboard rim tube.

AD02
AD-05

3. Inspection

- a. Rim for complete welds

AD06

4. Frame assembly – body

- a. General
 - i. Vent holes shall be #30 (0.129), and located inside the structure wherever possible to allow venting of weld gasses through existing holes (i.e. lid prop bushing, hoops, etc.)
- b. Grind corner welds from step 2 on rim to allow hoops to sit flat.
- c. Pull required hoops from stock - standard, attachment, handle.
 - i. If hoops are not in stock see detailed procedure sheet for specific hoop fabrication.
 - ii. Ensure vent hole is located at centre of tube to vent spine tubes.
- d. Assemble hoops with attachment lug locating jig and hoop spacing jig.
 - i. Ensure correct order and orientation of hoops. Refer to drawing.
 - 1. Attachment lugs are on inboard side.
 - 2. Handle bracket bushings are on outboard side, second hoop from both ends.
May be on attachment hoops.
 - ii. Run 3/8-24 tap into attachment lugs to ensure clear threads.
 - iii. Bolt attachment lug locating jig to attachment hoops with 3/8-24 bolts.
 - iv. Attach inboard and outboard hoop spacing jigs to all hoops using 1" C-clamps. Raise jigs approximately 2" off table to allow room to weld around hoops.
 - v. Attach bottom (spine) jig to all hoops using 1" C-clamps along the centre line of the basket. Ensure jig is straight prior to tightening all clamps.
- e. Cut $\frac{1}{2}$ " x 0.035 material to fit spine jig.
- f. Cut $\frac{1}{2}$ " x 0.035 material for strut to fit from lower inboard attachment to upper outboard rim.
 - i. Refer to applicable drawing for position, not required on some baskets.
- g. Option: Cut $\frac{1}{2}$ " x 0.035 material for front end cutout. Record material PO on attached material list.
- h. 90611 (R44) only: Cut $\frac{1}{2}$ " x 0.035 material to fit front end structure. Record material PO on attached material list.
- i. Drill vent holes into attachment hoop and/or rim to vent strut(s) and front end cutout.

AD06

- j. Record hoop WOs and material POs on attached material list.
- k. Remove writing on tubes with acetone and scotch bright.
- l. Insert rim assembly into jig and set frame assembly onto rim. Ensure correct orientation of lid prop bushings in rim to frame. Bushing hole must be closer to attachment side.
- m. Align hoops to rim in accordance with drawing. General positions:
 - i. Extra large baskets
 - 1. inboard side of hoops (attachment side) aligns to OUTSIDE of rim
 - 2. outboard side of hoops (handle side) aligns to INSIDE of rim
 - 3. forward and aft hoops align to INSIDE of rim
 - ii. All other baskets
 - 1. inboard side of hoops (attachment side) aligns to INSIDE of rim
 - 2. outboard side of hoops (handle side) aligns to INSIDE of rim
 - 3. forward and aft hoops align to INSIDE of rim, except R44

5. TIG weld frame to rim assembly.

- a. Ensure lug locating jig and hoop locating jigs are in place. Jigs must remain in place for as long as practical during welding.
- b. Strut tubes and front end cutout (see step 4.f. and g.) must be welded in place after the hoops are welded to the rim. Jig(s) must be in place prior to welding strut tubes.
- c. Robinson R44 (90611) requires fitting and welding of forward end after remainder of basket frame is welded. Use jig to support front hoop.
- d. Record welding rod PO on attached material list.

AD-05

6. Inspection

- a. Frame assembly for complete welds.

AD-06

7. Mesh assembly.

- a. Pull sheet of expanded mesh from stock. Record material PO on attached material list.
- b. Cut mesh to size for body.
- c. Remove surface rust with scotch-brite.
- d. Bend body mesh – use table with bend markings on top. Lock wheels on table.
 - i. For extra wide baskets only –
 - 1. Set $\frac{3}{4}$ " angle along edge of table under mesh sheet. Set 1.5" square tube on top of mesh aligned with angle on edge of table. Clamp in place with 6" C-clamps.
 - 2. Bend upper edge of sheet just past a cell intersection to make a flange 2.5" - 3.25" wide. Closer to 2.5" is preferred, full cell intersection on flange side at bend is required.
 - 3. Bend down by hand as far as possible, then use a hammer to flatten the bend tight against the angle on the edge of the table.
 - ii. Using markings on table, align sheet to indicated edge.
 - iii. Using markings on table, align 3" tube to required position and clamp tube in place.
 - iv. Bend mesh by hand tightly over tube along length of tube.
 - v. Keeping mesh in place, un-clamp 3" tube, move to other position and clamp tube in place.
 - vi. Bend mesh by hand tightly over tube along length of tube.
- e. Install attachment lug jig onto basket frame.

AD-07

- f. Ensure end struts are welded in basket frame if required by the drawing.
- g. Insert mesh into basket.
 - i. General
 - 1. Some cells may interfere with correct positioning, especially at the upper corners and around struts. Bend cell(s) in as required, do not cut cells off.
 - 2. Ideally welds will be located on mesh intersections. Shift mesh if possible to minimize welds located off mesh intersections.
 - 3. Ensure mesh reaches all edges of basket BEFORE trimming. Regardless of progress in clamping, remove clamps and shift mesh if required.
 - 4. Ensure cleco clamps are placed from the inside of the basket to allow removal during welding. Cleco clamps may be used from the outside during fitting, but must be removed prior to welding.
 - ii. Extra large baskets only – seat corner of mesh with flange into inboard upper corner of frame. Use C-clamps on edge of flange as required to maintain tight fit.
 - iii. Starting at inboard top edge of basket, clamp mesh to hoop near top rim using cleco clamps onto hoops. For regular size baskets, edge of mesh should sit approximately half way up rim tube.
 - iv. Working down the inboard side, clamp mesh to hoops with cleco clamps. Clamp down into radius of hoop and continue clamping as required to maintain tight fit in corner of hoop. After the corners are tight, two clamps just onto the radius on both ends should be sufficient to hold the corner tight, remove all extra clamps.
 - v. Clamp mesh to spine in at least 1 place per section.
 - vi. Working up the outboard side, clamp the mesh into the radius of hoop and continue clamping as required to maintain tight fit in corner of hoop. After the corners are tight, 2 clamps just onto the radius on both ends should be sufficient to hold the corner tight, remove all extra clamps.
 - vii. Trim upper outboard edge of mesh if required, edge of mesh must be low enough on rim tube to prevent the weld from protruding above the edge of the rim. Some sheets are tapered and may require $\frac{1}{2}$ to 1 cell to be removed over some or all of the length of the basket. De-burr cut edges with a sanding disc on a die-grinder. Straighten cut cells with duck-bill pliers. Clamp mesh near upper edge to hoops with cleco clamps after trimming.
 - viii. Trim ends to land on hoops, at mesh intersections if possible.
- h. Cut mesh to fit ends. Record material PO on attached material list.
 - i. Remove surface rust with scotch-brite.
 - ii. Ensure mesh is cut at intersections where possible.
 - iii. Bend top edge of mesh 1/8"-3/16" down at 45 degrees
 - iv. Cut for front end cutout if required.
- i. 90611 (R44) only: Cut mesh to fit upper forward end. Record material PO on attached material list.
 - i. Remove surface rust with scotch-brite.
 - ii. Ensure mesh is cut at intersections where possible.
 - iii. Bend top edge of mesh 1/4" down at 60 degrees.
 - iv. Fit mesh to front end of basket.

CARGO BASKET BODY FABRICATION - COMMON

Complete
(initial or SCA #)

AD-05

8. Weld mesh to frame assembly per drawing.
 - a. Ensure lug locating jig is in place prior to welding.
 - b. General welding requirements for all baskets, MIG welding:
 - i. Every intersection at top edges.
 - ii. Every intersection at ends.
 - iii. First 5 intersections down on hoops, then every second intersection.
 - iv. Every intersection along spine.
 - v. Extra large baskets – every intersection along corner.
 - vi. Every intersection around ends
 - vii. Every intersection along struts (if applicable)
 - c. Bend and trim cells bent in to fit mesh as required and weld in position.
 - d. Grind high spots off body mesh welds on ends before welding end mesh.
 - e. 90611 (R44) only – weld lid prop bushing (step 9) into rim BEFORE welding upper mesh on forward end of basket assembly.
 - f. Record welding rod PO on attached material list.

9. Weld basket components

- a. TIG weld lid prop bushing(s), one or two per drawing.
 - i. Record welding rod PO on attached material list.
 - ii. Record lip prop bushing WO on attached material list.
- b. TIG weld caps to close top of 1" hoops as applicable.
- c. 94611 (Bell206L/407 XL ski) only: cut rim over cross tube gap.
 - i. Cut inboard rim on aft end. Grind flush with hoops.
 - ii. TIG weld caps on open tubes.
 - iii. Record cap material PO on attached material list.
- d. 95911 (Bell 429) only: placard bracket to forward upper corner of basket.
 - i. Record welding rod PO on attached material list.
 - ii. Record placard bracket WO on attached material list.

AD-05

10. Clean up

- a. Grind high spots off mesh welds.
- b. Tighten mesh using special pliers. Tighten enough to remove "oil canning", where mesh springs in or out. Do not tighten in corners of hoops, mesh will be deformed.
- c. Drill #9 through lid prop bushing(s). De-burr hole(s).
- d. Remove surface rust with scotch-brite pad.

AD-06

11. Final Inspection

To be completed by a different person than the previous steps.

- a. Basket body assembly for complete welds, and required minimum mesh weld locations.
- b. Filled vent holes – usually on hoops
- c. Overall condition and conformity to drawing(s).
 - i. Hoops for height.
 - ii. Rim for width and length and alignment.
 - iii. Lid prop lugs in correct ends.
 - iv. Fore/aft strut in hoop if required by drawing.
- d. Material lists complete.

AD-07

CARGO BASKET BODY FABRICATION - COMMON

Complete
(initial or SCA #)

- e. Tag complete basket body assembly in preparation for powder coating.

12. Powder Coating

- a. Parts are to be powder coated white in accordance with commercial practices.
- b. Record powder coating PO.
- c. Inspect powder coating on receiving.
- d. Tag basket body assembly and place into stock in preparation for assembly.

ADD

Work Order: 2014-34Date Opened: 25 MAR 2014

Material Tracking Sheet

Bell 206L / 407

Extra Wide Ski Basket Body Fabrication

1 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	<u>1</u>		94611-01	Basket Assembly		
Step 1				<i>Rim Assembly</i>		
	. 2		--	3/4" Tube - Long Rim (97")	4130 Steel, 3/4" x 0.035 Sqr. Tube	<u>14009</u>
	. 2		--	3/4" Tube - Short Rim (25.5")	4130 Steel, 3/4" x 0.035 Sqr. Tube	<u>13087</u>
	. 1		--	3/4" Tube - Long stringer (95.5")	4130 Steel, 3/4" x 0.035 Sqr. Tube	<u>14009</u>
	. 5		--	3/4" Tube - Short Rim (2.5")	4130 Steel, 3/4" x 0.035 Sqr. Tube	<u>1211</u>
	. 4		94621-02	Insert	1018 Mild Steel, 3/8" Rod	<u>2013-25 / 12056</u>
Step 2				<i>Weld Rim Assembly</i>		
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	<u>PO# 14005</u>
Step 3				<i>Inspection - Rim</i>	None	
Step 4				<i>Frame Assembly</i>		
	. 2		94520-01	Hoop - standard	4130 Steel, 1/2" x 0.035 Sqr. Tube	<u>12123</u>
	. 1	84262	94520-01	Hoop - with handle provisions	4130 Steel, 1/2" x 0.035 Sqr. Tube	<u>12123 / 13023-Bushing</u>
	. 1		94521-01	Forward Attachment Hoop		
	. 1		94522-01	Aft Attachment hoop - with handle provisions		<u>12123 / 13023-Bushing</u>
	. 2		94620-01	Hoop - short		
	. 5		--	1/2" Tube - spine	4130 Steel, 1/2" x 0.035 Sqr. Tube	<u>14009</u>
	. 3		--	1/2" Tube - strut	4130 Steel, 1/2" x 0.035 Sqr. Tube	<u>14009</u>
	. 1		--	1/2" Tube - cross tube bridge	4130 Steel, 1/2" x 0.035 Sqr. Tube	<u>14009</u>
Step 4.g.		70411	70411-01	Option: Front End Cutout		
			70411-03	1/2" Tube	4130 Steel, 1/2" x 0.035 Sqr. Tube	
			70411-04	1/2" Tube	4130 Steel, 1/2" x 0.035 Sqr. Tube	
Step 5				<i>Weld Frame Assembly</i>		
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	<u>PO# 14005</u>

Work Order: 204-34

Material Tracking Sheet

2 of 2

Bell 206L / 407

Date Opened: 25 MAR 2014

Extra Wide Ski Basket Body Fabrication

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 6				<i>Inspection - Frame Assembly</i>	<i>None</i>	
Step 7				<i>Mesh Assembly</i>		
	. 1		--	Mesh (Body - 56" x 96")	3/4-16F Expanded Mild Steel sheet	14612
	. 4		--	Mesh (End - 24.75" x 16.75")	3/4-16F Expanded Mild Steel sheet	12130
	. 1		--	Mesh (Cutout - 24" x 8")	3/4-16F Expanded Mild Steel sheet	12130
Step 8				<i>Weld Mesh</i>		
	. A/R		--	Welding Rod	ER70S-6 MIG Wire	PO# 14005
Step 9				<i>Weld Basket Components</i>		
Step 9.a.	. 1		49215-01	Spacer (Lid prop)	304 Stainless Steel, 1/2" Dia.	WO# 2013-SS
	. A/R		--	Welding Rod	ER308L TIG Rod	PO# 14028
Step 9.c.	. 2		--	Cap	1018 Mild Steel, 0.032" Sheet	PO# 9010
	. A/R		--	Welding Rod	ER70S-2	PO# 14005
Step 10				<i>Clean Up</i>	<i>None</i>	
Step 11				<i>Inspection - Final Assembly</i>	<i>None</i>	
Step 12				<i>Powder Coating</i>		

Date Opened: 25 March 2014

Job #: 946

Type / Project: Bell 206L/407 Extra-Wide Long Cargo Basket

Batch Quantity: 1

Approval: SH00-48

Drawing List: DCL946-10, Rev. 0

Drawing	Description	Task Sheet		Material List	
		Provided	Complete	Provided	Complete
94610, Rev. 0	Cargo Basket Assembly	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
- 84255, Rev. 1	Handle Assembly	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
94611, Rev. 0	Basket Body Fabrication	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>
<input type="checkbox"/> 70411, Rev. 0	Front End Cutout (Option)	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
94612, Rev. 0	Basket Lid Fabrication	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>
- 84262, Rev. 0	Lid Handle Provisions	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
<input checked="" type="checkbox"/> 70405, Rev. 3	Lid Walk Way (Option)	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
94620, Rev. 0	Hoop	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
94520, Rev. 0	Hoop	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
- 84262, Rev. 1	Basket Handle Provisions	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
94521, Rev. 0	Forward Attachment Hoop	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
94522, Rev. 0	Aft Attachment Hoop	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
84261, Rev. 1	Handle Bar Assembly	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>

Work Order pre-completion Inspection:

Project is on Approval Limitation Record:

Document Control List revision level matches (or exceeds) STC:

Drawings revision levels match Document Control List:

Y
Y
Y

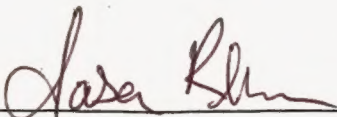
Purchase order or Work order source is recorded for each part/ass'y:

Tests and inspections specifically called out on drawings are complete:

Release tags associated with all fabricated parts are attached:

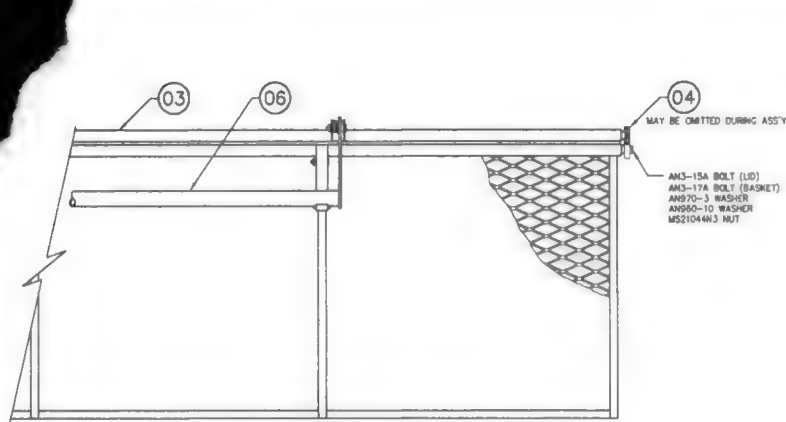
Y
Y
Y

List all non-conformities raised: _____

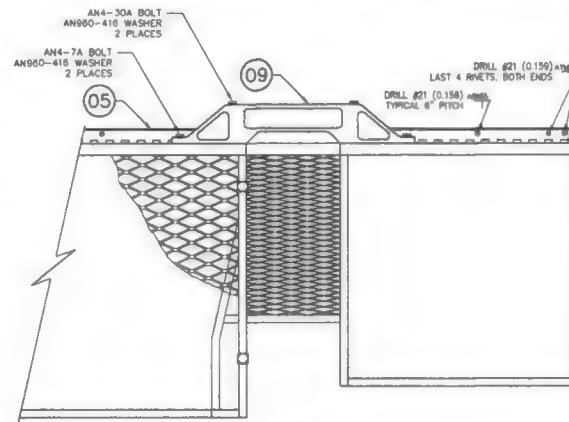
Inspector Signature: 

Date: _____

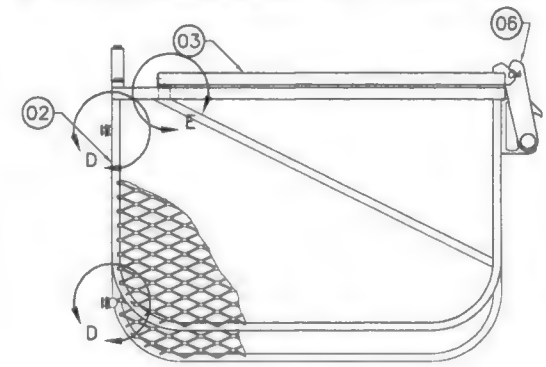
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REV	DESCRIPTION OF CHANGE	INITIALS	DATE
0	CREATED FROM 94511, REV. 0		



VIEW A
LOOKING AT FORWARD OUTBOARD SIDE

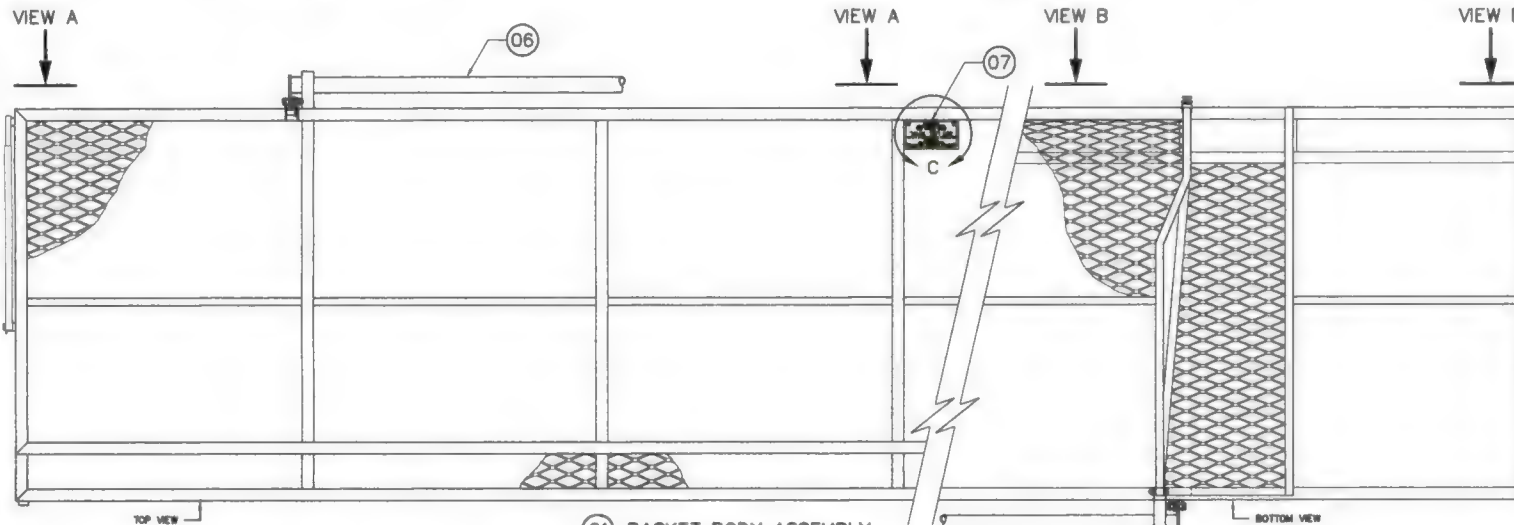


VIEW B
LOOKING AT AFT INBOARD SIDE

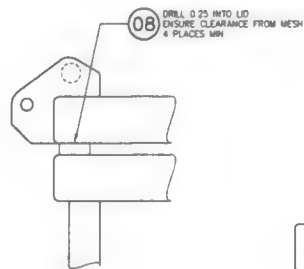


DETAIL D

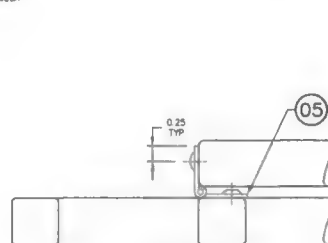
SCALE 1 : 1
LOOKING AT LOWER ATTACHMENT, UPPER ATTACHMENT SIMILAR
TYPICAL FRONT AND REAR



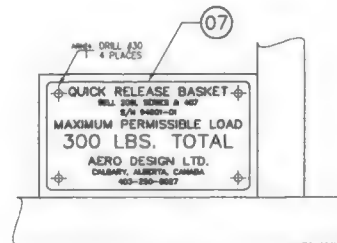
01 BASKET BODY ASSEMBLY



BUMPER INSTALLATION
SCALE 1 : 1



DETAIL E
SCALE 1 : 1
LOOKING AT HINGE



DETAIL C
SCALE 1 : 1
LOOKING AT PLACARD BRACKET

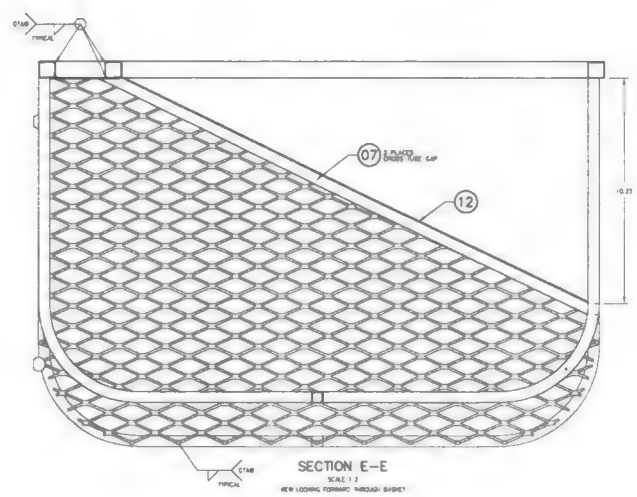
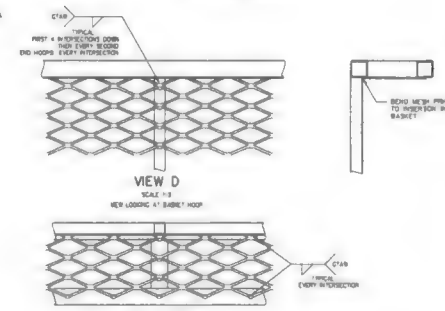
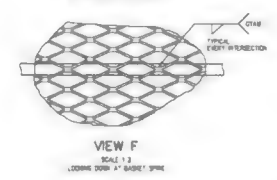
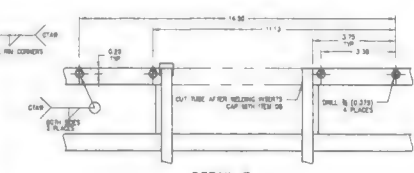
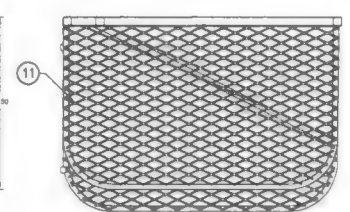
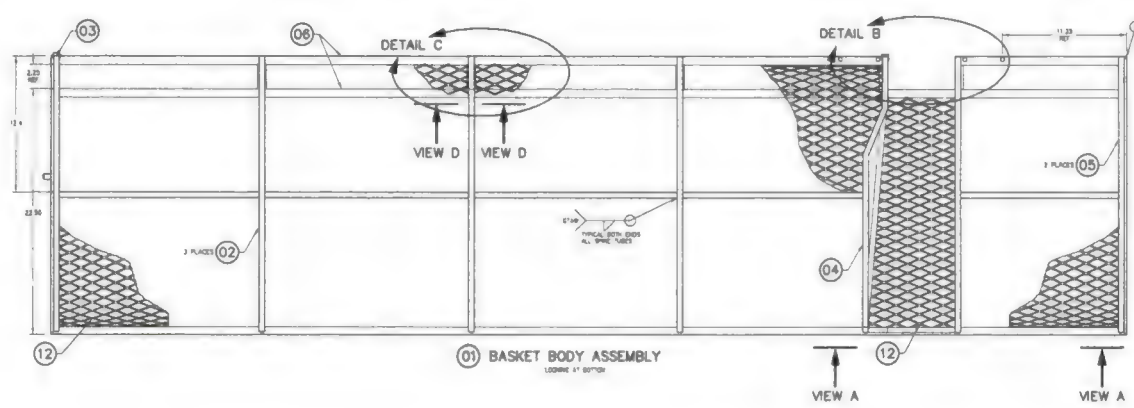
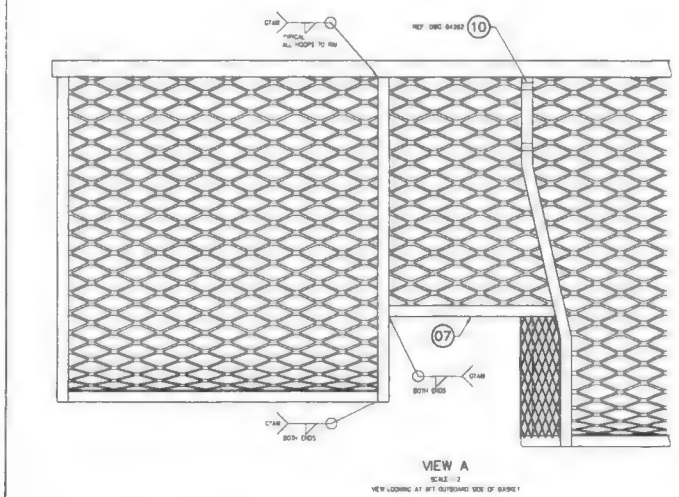
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2	AN4-30A	BOLT		
2	AN4-7A	BOLT		
4	AN980-616	WASHER		
4	40088-14	FITTING		ANCR4
4	CR3213-4-02	CHERRY RIVET		
8	CR3523-5-02	CHERRY RIVET		
4	CR3213-5-02	CHERRY RIVET		
1	94821-01	BRACE		
4	49205-14	BUMPER		ARGUS INDUSTRIES
1	94822-01	PLACARD		
1	84255-01	HANDLE BAR INSTALLATION		
1	MS20001P4	PIANO HINGE		
1	36280-01	BRACE ASSEMBLY		
1	94812-01	LID ASSEMBLY		
1	94511-01	BASKET BODY ASSEMBLY		
1	94610-01	CARGO BASKET ASSEMBLY		

LIST OF MATERIALS

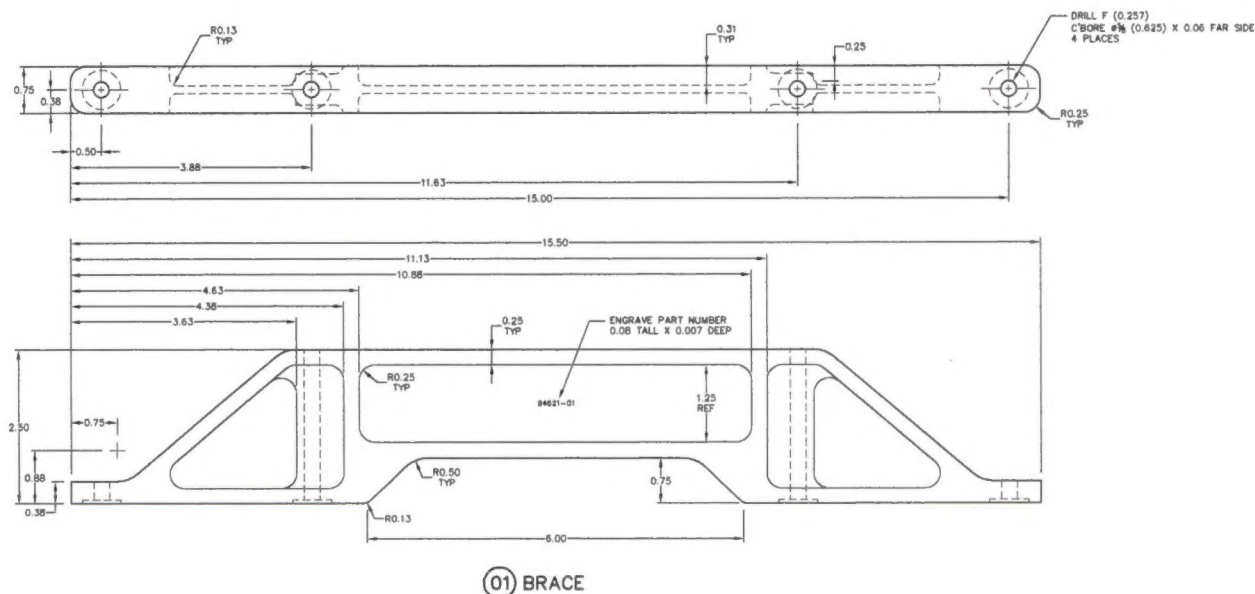
BASIC CODE	DASH NO. FOR DIAMETER	APPROVALS	DATE
REF: HAS 523	No-MTD HEAD NEAR SIDE F-MTD HEAD FAR SIDE	DRAWN: JEFF CLARKE	24 OCT 2011
C-COUNTERSUNK	DASH NO. FOR LENGTH	CHECKED: E BURGOON	
D-COMPLE			
DIGIT# OF SHEETS			
TO BE DIMPLED			
BASIC CODES:			
BJ = MS20470AD	+ INSTALL NEW RIVET		
BB = MS20426AD	+ REMOVE/REPLACE RIVET		
ARH = CR3213	- EXISTING RIVET		
ATM = CR3523			

AERO DESIGN LTD.			
CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M			
2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7			
tel: (403) 250-8087 fax: (403) 250-8353 aerodesign@atshughes.net			
BELL 206L SERIES, 407			
QUICK RELEASE CARGO BASKET			
CARGO BASKET ASSEMBLY			
SCALE	DWG SIZE	DWG NO	REV
1 : 1	A1	94610	0
SHEET 1 OF 1			

-

[illegible]

THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREON.			
REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		



NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. THOROUGHLY DEGREASE, ALODINE, PRIME, AND PAINT ALL ALUMINUM PARTS PRIOR TO ASSEMBLY.
ALTERNATE: ALUMINUM PARTS TO BE ANODIZED IN ACCORDANCE WITH MIL-A-8625F, TYPE III, CLASS I

4	94621-02	02	INSERT	1018 MILD STEEL	AISI 1010/1020	0.375 ROD
1	94621-01	01	BRACE	6061-T6 ALUMINUM	QQ-A-200/8	1.5 X 0.75 BAR
PART NO.		ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
LIST OF MATERIALS						
QTY						
APPROVALS				DATE		
DRAWN: JEFF CLARKE				25 OCT 2011		
CHECKED: E. BURGON						
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:				AERO DESIGN LTD. CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M 2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7 tel: (403) 250-8807 fax: (403) 250-8933 www.aerodesign.ca		
DECIMALS				BELL 206L SERIES, 407 QUICK RELEASE CARGO BASKET BRACE FABRICATION		
X.XXX ±0.010				SCALE 1 : 1		
X.XX ±0.03				DWG. SIZE		
X.X ±0.1				DWG. NO.		
				REV.		
SHEET 1 OF 1				A1 94621 0		

NOTICE

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	ORIGINAL ISSUE		

NOTES

1. ENGRAVE 0.007 DEEP AS FOLLOWS:

- "QUICK RELEASE BASKET" - 0.125 HIGH
- "BELL 206L SERIES & 407" - 0.080 HIGH
- "S/N 94601-XX" - 0.080 HIGH
- "MAXIMUM PERMISSIBLE LOAD" - 0.125 HIGH
- "300 LBS. TOTAL" - 0.200 HIGH
- "AERO DESIGN LTD." - 0.125 HIGH
- "CALGARY, ALBERTA, CANADA" - 0.080 HIGH
- "403-250-8027" - 0.080 HIGH

DRILL #30 (0.129)
4 PLACES



01 PLACARD

1	94627-01	01	PLACARD	6061-T6 ALUMINUM	QQ-A-250/11	0.050 SHEET
01	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS					
			APPROVALS	DATE	AERO DESIGN LTD. CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M 2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7 tel: (403) 250-8027 fax: (403) 250-8333 aerodesign@telusplanet.net	
			DRAWN: JEFF CLARKE	16 SEPT 2011		
			CHECKED: E. BURGAIN			
			UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2" X.XX ±0.03 X.X ±0.1		BELL 206L SERIES, 407 QUICK RELEASE CARGO BASKET PLACARD	
			SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
			SHEET 1 OF 1	A1	94627	0

[illegible]